

Date: Thursday, 3/8/2007 3:40:58 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 31148		
Estimate Number	: 12704		
P.O. Number	: N/A	Part Number	: D35501
This Issue	: 3/8/2007 S.O. No. : N/A	Drawing Number	: D3550 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 30690	Material	: N/A
Written By	:	Due Date	: 3/30/2007 Qty: 30 Um: Each
Checked & Approved By	: <u>07.03.08</u>		
Comment	: Est. A 07.02.05 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 1.7850 f(s)/Unit Total : 53.5500 f(s)
 304 RD Tube .500 x .049W
 304/316 Seamless tubing, 1/2" OD x .049 Wall

Batch M103841 SB 07/03/20 (30)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Form per Dwg D3550

SB 07/03/20 (30)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

MF 07-03-22 (30)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/03/22 (30)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M-L 07/03/23 (30X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 3:40:58 PM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 31148

Part Number: D35501

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/13/26 (30)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6/13/26

59 7/03/26

(30)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

6/13/27

Job Completion



U 87-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

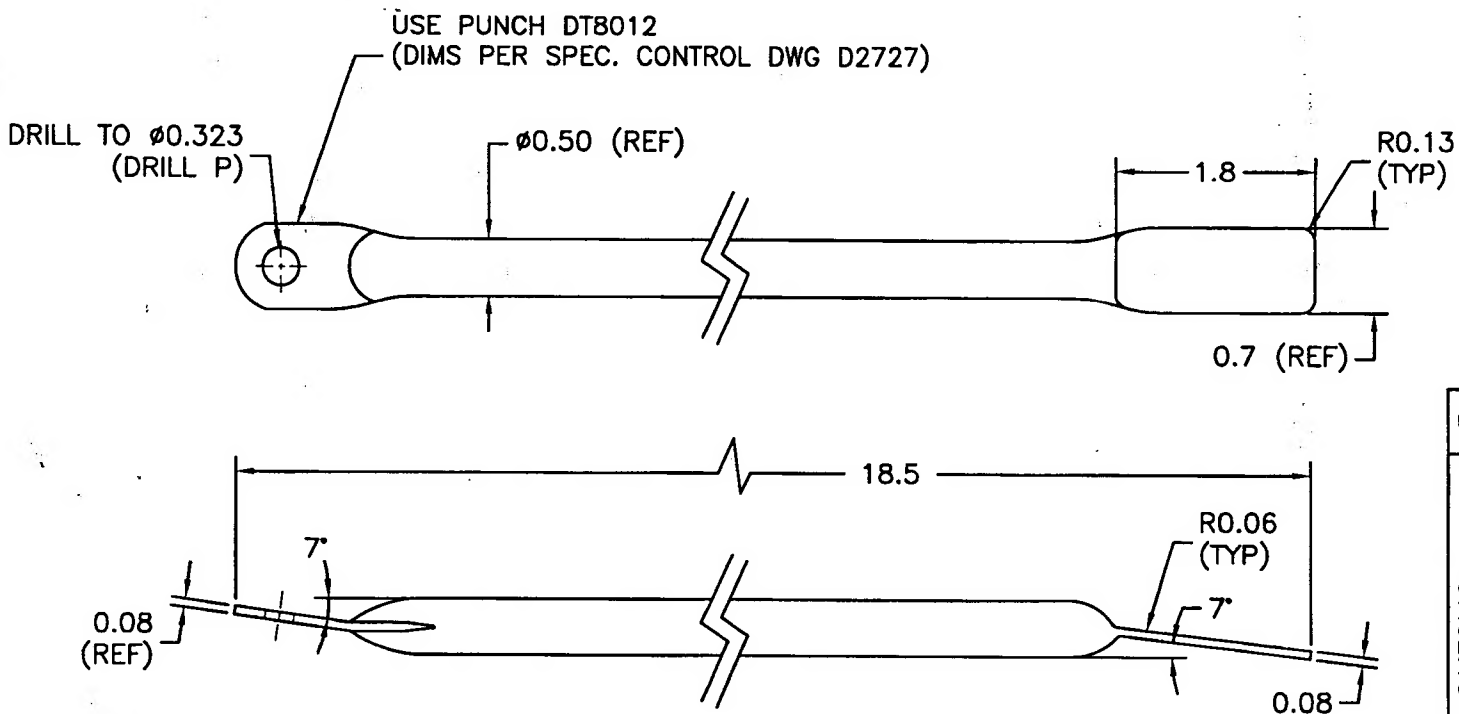
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CE	CE	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH	PH	D3550	SHEET 1 OF 1
DATE	TITLE	SCALE	
07.02.13	STRUT	NTS	
A	06.10.24	NEW ISSUE	
B	07.02.13	18.5 WAS 20.13; 1.8 WAS 1.5	



D3550-1 STRUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 31148

NOTES:

- 1) MATERIAL: 304/316 SS SEAMLESS ROUND TUBE 0.500 OD X 0.049 WALL
(REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3550-1 USING FINE POINT PERMANENT INK MARKER

RELEASED
07.02.13